

(12) INTERNATIONAL APPLICATION PUBLISHED UNDER THE PATENT COOPERATION TREATY (PCT)

(19) World Intellectual Property Organization
International Bureau(43) International Publication Date
20 December 2001 (20.12.2001)

PCT

(10) International Publication Number
WO 01/97310 A2(51) International Patent Classification⁷: H01M 8/04

RIVARD, Pierre [CA/CA]; 113 Hove Street, Toronto, Ontario M3H 4Z5 (CA). CARGNELLI, Joseph [CA/CA]; 59 Lapp Street, Toronto, Ontario M6N 3W3 (CA).

(21) International Application Number: PCT/CA01/00854

(22) International Filing Date: 13 June 2001 (13.06.2001)

(74) Agent: BERESKIN & PARR; 40 King Street West, 40th Floor, Toronto, Ontario M5H 3Y2 (CA).

(25) Filing Language: English

(26) Publication Language: English

(30) Priority Data:
09/592,347 13 June 2000 (13.06.2000) US(81) Designated States (*national*): AL, AG, AI, AM, AT, AU, AZ, BA, BB, BG, BR, BY, BZ, CA, CH, CN, CO, CR, CU, CZ, DE, DK, DM, DZ, EE, ES, FI, GB, GD, GL, GR, GM, HR, HU, ID, IL, IN, IS, JP, KB, KG, KP, KR, KZ, LC, LK, LR, LS, LT, LU, LV, MA, MD, MG, MK, MN, MW, MX, MZ, NO, NZ, PL, PT, RO, RU, SD, SI, SG, SL, SK, SR, TJ, TM, TR, TT, TZ, UA, UG, US, UZ, VN, YU, ZA, ZW.(63) Related by continuation (CON) or continuation-in-part (CIP) to earlier application:
US 09/592,347 (CON)
Filed on 13 June 2000 (13.06.2000)(84) Designated States (*regional*): ARIPO patent (GI, GM, KB, LS, MW, MZ, SD, SL, SZ, TZ, UG, ZW), Eurasian patent (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM), European patent (AT, BE, CH, CY, DE, DK, ES, FI, FR, GB, GR, IE, IT, LU, MC, NL, PT, SE, TR), OAPI patent (BF, BJ, CF, CG, CI, CM, GA, GN, GW, ML, MR, NI, SN, TD, TG).(71) Applicant (*for all designated States except US*): HYDROGENICS CORPORATION [CA/CA]; 5985 McLaughlin Road, Mississauga, Ontario L5R 1B8 (CA).

Published:

— *without international search report and to be republished upon receipt of that report*

(72) Inventors; and

(75) Inventors/Applicants (*for US only*): FRANK, David [CA/CA]; 25 Cleithropes Blvd., Scarborough, Ontario M1S 2S7 (CA). CHEN, Xuesong [CN/CA]; #1817 - 2 Hanover Road, Brampton, Ontario L6S 4H9 (CA).*For two-letter codes and other abbreviations, refer to the "Guidance Notes on Codes and Abbreviations" appearing at the beginning of each regular issue of the PCT Gazette.*

WO 01/97310 A2

(54) Title: CATALYTIC HUMIDIFIER AND HEATER, PRIMARILY FOR HUMIDIFICATION OF THE OXIDANT STREAM FOR A FUEL CELL

(57) Abstract: A method and apparatus are provided for humidifying oxidant supplied to a fuel cell system, which can be a single fuel cell or a multiplicity of fuel cells. A catalytic reactor is provided, which is supplied with a portion of the fuel and the oxidant. The oxidant is supplied in excess of the fuel to the reactor, so as to generate a stream of oxidant which is both heated and humidified. For an air breathing stack, this heated oxidant can simply be mixed with air flowing through the fuel cell stack. For a closed system, a heated and humidified oxidant flow, and optionally a fuel flow are mixed with additional flows of these gases supplied to the fuel cell.

WO 01/97310

PCT/CA01/00854

**Title: CATALYTIC HUMIDIFIER AND HEATER, PRIMARILY FOR
HUMIDIFICATION OF THE OXIDANT STREAM FOR A FUEL CELL**

FIELD OF THE INVENTION

5 This invention relates to electrochemical fuel cells, more particularly electrochemical fuel cells which employ hydrogen as a fuel and receive an oxidant to convert the hydrogen to electricity and heat. This invention is even more particularly concerned with the humidification requirements of such an electrochemical fuel cell employing a proton exchange membrane.

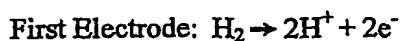
10

BACKGROUND OF THE INVENTION

 Generally, a fuel cell is a device which converts the energy of a chemical reaction into electricity. It differs from a battery in that the fuel cell can generate power as long as the fuel and oxidant are supplied.

15

 A fuel cell produces an electromotive force by bringing the fuel and oxidant into contact with two suitable electrodes and an electrolyte. A fuel, such as hydrogen gas, for example, is introduced at a first electrode where it reacts electrochemically in the presence of the electrolyte and catalyst to produce electrons and cations in the first electrode. The electrons are circulated from the first electrode to a second electrode through an electrical circuit connected between the electrodes. Cations pass through the electrolyte to the second electrode. Simultaneously, an oxidant, typically air, oxygen enriched air or oxygen, is introduced to the second electrode where the oxidant reacts electrochemically in presence of the electrolyte and catalyst, producing anions and consuming the electrons circulated through the electrical circuit; the cations are consumed at the second electrode. The anions formed at the second electrode or cathode react with the cations to form a reaction product such as water. The first electrode or anode may alternatively be referred to as a fuel or oxidizing electrode, and the second electrode may alternatively be referred to as an oxidant or reducing electrode. The half-cell reactions at the two electrodes are, respectively, as follows:

20
25
30

WO 01/97310

PCT/CA01/00854

- 2 -

The external electrical circuit withdraws electrical current and thus receives electrical power from the cell. The overall fuel cell reaction produces electrical energy which is the sum of the separate half-cell reactions written above. Water and heat are typical by-products of the reaction.

5 In practice, fuel cells are not operated as single units. Rather, fuel cells are connected in series, stacked one on top of the other, or placed side by side. A series of fuel cells, referred to as fuel cell stack, is normally enclosed in a housing. The fuel and oxidant are directed through manifolds to the electrodes, while cooling is provided either by the reactants or by a cooling medium. Also within the stack
10 are current collectors, cell-to-cell seals and insulation, with required piping and instrumentation provided externally of the fuel cell stack. The stack, housing, and associated hardware make up the fuel cell module.

Fuel cells may be classified by the type of electrolyte, which is either liquid or solid. The present invention is primarily concerned with fuel cells using a
15 solid electrolyte, such as a proton exchange membrane (PEM). The PEM has to be kept moist with water because the membranes that are currently available will not operate efficiently when dry. Consequently, the membrane requires constant humidification during the operation of the fuel cell, normally by adding water to the reactant gases, usually hydrogen and air.

20 The proton exchange membrane used in a solid polymer fuel cell acts as the electrolyte as well as a barrier for preventing the mixing of the reactant gases. An example of a suitable membrane is a copolymeric perfluorocarbon material containing basic units of a fluorinated carbon chain and sulphonic acid groups. There may be variations in the molecular configurations of this membrane.
25 Excellent performances are obtained using these membranes if the fuel cells are operated under fully hydrated, essentially water-saturated conditions. As such, the membrane must be continuously humidified, but at the same time the membrane must not be over humidified or flooded as this degrades performances. Furthermore, the temperature of the fuel cell stack must be kept above freezing in order to
30 prevent freezing of the stack.

Cooling, humidification and pressurization requirements increase the cost and complexity of the fuel cell, reducing its commercial appeal as an

WO 01/97310

PCT/CA01/00854

- 3 -

alternative energy supply in many applications. Accordingly, advances in fuel cell research are enabling fuel cells to operate without reactant conditioning, and under air-breathing, atmospheric conditions while maintaining usable power output.

5 The current state-of-the-art in fuel cells, although increasingly focusing on simplified air-breathing, atmospheric designs, has not adequately addressed operations in sub-zero temperatures, which requires further complexity in the design. For instance, heat exchangers and thermal insulation are required, as are additional control protocols for startup, shut-down, and reactant humidifiers.

10 Where a solid polymer proton exchange membrane (PEM) is employed, this is generally disposed between two electrodes formed of porous, electrically conductive material. The electrodes are generally impregnated or coated with a hydrophobic polymer such as polytetrafluoroethylene. A catalyst is provided at each membrane/electrode interface, to catalyze the desired electrochemical reaction, with a finely divided catalyst typically being employed. The membrane/electrode
15 assembly is mounted between two electrically conductive plates, each which has at least one (fluid) flow passage formed therein. The fluid flow conductive fuel plates are typically formed of graphite. The flow passages direct the fuel and oxidant to the respective electrodes, namely the anode on the fuel side and the cathode on the oxidant side. The electrodes are electrically connected in an electric circuit, to
20 provide a path for conducting electrons between the electrodes. Electrical switching equipment and the like can be provided in the electric circuit as in any conventional electric circuit. The fuel commonly used for such fuel cells is hydrogen, or hydrogen rich reformat from other fuels ("reformat" refers to a fuel derived by reforming a hydrocarbon fuel into a gaseous fuel comprising hydrogen and other
25 gases). The oxidant on the cathode side can be provided from a variety of sources. For some applications, it is desirable to provide pure oxygen, in order to make a more compact fuel cell, reduce the size of flow passages, etc. However, it is common to provide air as the oxidant, as this is readily available and does not require any separate or bottled gas supply. Moreover, where space limitations are
30 not an issue, e.g. stationary applications and the like, it is convenient to provide air at atmospheric pressure. In such cases, it is common to simply provide channels through the stack of fuel cells to allow for flow of air as the oxidant, thereby greatly

WO 01/97310

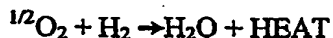
PCT/CA01/00854

- 4 -

simplifying the overall structure of the fuel cell assembly. Rather than having to provide a separate circuit for oxidant, the fuel cell stack can be arranged simply to provide a vent, and possibly some fan or the like to enhance air flow.

Catalytic burners are also known and operate on a principle similar to fuel cells, but at an accelerated kinetic rate and increased temperature. A fuel, for example hydrogen, is oxidized through direct contact with oxygen or air at a rate induced by the presence of a catalytic bed, for example, ceramic beads containing small amounts of platinum on the surface.

The by-product of the chemical reaction is similar to that of a fuel cell, but without any generation of electricity:



The higher consumption rate of the reactants and concomitant heat release reflects the fact that the reaction occurs through direct contact rather than through a proton/electron transaction. Catalytic burning is flameless, and occurs at a temperature between that of a fuel cell's "cold combustion" and that of an open-flame combustion. Flow rate can be pulsed or modulated to achieve varying temperature profiles. Hydrogen catalytic burning requires no pilot flame or spark to be initiated.

An example of a proposal for a catalytic burner is found in an article entitled "Catalytic Combustion of Hydrogen in a Diffusive Burner" by K. Stephen and B. Dahm at pages 1483 - 1492 of Catalytic Combustion of Hydrogen in a Diffusive Burner.

SUMMARY OF THE INVENTION

In accordance with a first aspect of the present invention, there is provided a tubular reactor, for catalyzing the reaction of hydrogen and a gaseous oxidant, the tubular reactor comprising:

an elongated housing, a catalyst formed from a material adapted to promote catalytic combustion of the fuel and the oxidant, being formed into an elongated body substantially filling the elongate housing and being porous, a first inlet for a gaseous fuel and a second inlet for a gaseous oxidant, both first and second inlets being provided at one end of the elongated housing;

WO 01/97310

PCT/CA01/00854

- 5 -

and an outlet at the other end of the housing, whereby, in use, the catalyst promotes combustion between the fuel and the oxidant to generate heat and moisture, whereby a heated and humidified gas flow exits through the outlet.

5 Preferably, the housing and the body of the catalyst are both generally cylindrical and have length substantially longer than the diameter than the tubular reactor.

In accordance with a second aspect of the present invention, there is provided a fuel cell system comprising at least one fuel cell, each fuel cell comprising:

10 an inlet for a fuel;

an anode having a catalyst associated therewith for producing cations from the fuel;

a fuel manifold, connected between the inlet and the anode, for distributing fuel to the anode;

15 an oxidant inlet means for supplying oxidant;

a cathode having a catalyst associated therewith and connected to the oxidant inlet means, for producing anions from the oxidant, said anions reacting with said cations to form water on said cathode;

20 an ion exchange membrane deposited between said anode and said cathode, said membrane facilitating migration of cations from said anode to said cathode, while isolating the fuel and the oxidant from one another;

the catalytic reactor having a first inlet for fuel and a second inlet for an oxidant, and an outlet for heated and humidified gas, the catalytic reactor being mounted to supply the heated and humidified gas to the fuel cell.

25 Preferably, the fuel cell system comprises a plurality of fuel cells, forming a fuel cell stack.

The stack can comprise an air-breathing stack, including a plurality of channels extending through the fuel cell stack for permitting free flow of ambient air as the oxidant through the fuel cell stack, there being at least one channel for
30 each fuel cell, wherein the catalytic reactor is mounted below the fuel cell stack. The catalytic converter is configured to receive air as an oxidant through the second inlet thereof in excess of the stoichiometric quantity of air required for combustion

WO 01/97310

PCT/CA01/00854

- 6 -

of fuel within the catalytic reactor, whereby heated and humidified air is discharged from the outlet of the catalytic reactor. The outlet of the catalytic reactor is mounted below the channels of the fuel cell stack, whereby, heated and moistened air flows upwardly through the channels of the fuel cell stack from the catalytic reactor.

5 The catalytic reactor can be either generally tubular or it can be disk-shaped, configured for flow of fuel and oxidant generally along the central axis of the reactor.

 A further aspect of the present invention provides a method of operating a fuel cell system comprising a plurality of fuel cells, each fuel cell comprising an
10 inlet for fuel, an anode having a catalyst associated therewith for producing cations from fuel, a fuel manifold connected between the inlet and the anode for distributing fuel to the anode, an oxidant inlet means for supplying oxidant, a cathode having a catalyst associated therewith and connected to the oxidant inlet means for producing anions from the oxidant, said anions reacting with said cations
15 to form water on said cathode and an ion exchange membrane disposed between the anode and the cathode, for facilitating migration of cations from the anode to the cathode, while isolating the fuel and oxidant from one another, the method comprising

 (a) supplying oxidant and fuel to the fuel cell for reaction to
20 generate electrical power and heat;

 (b) supplying fuel to the catalytic reactor and oxidant to the catalytic reactor, in an amount greater than the stoichiometric amount required for the combustion of the fuel, to ensure complete combustion of the fuel, thereby generating a flow of heated and humidified oxidant;

25 (c) supplying the heated and humidified oxidant to the fuel cell, for reaction with the fuel to generate electricity and heat.

 For initial start-up below a preset temperature, the method can comprise initially supplying fuel and oxidant only to the catalytic reactor to generate a flow of heated and moistened oxidant, and passing the heated and moistened oxidant
30 through the fuel cell to preheat the fuel cell, and commencing supply of fuel to the fuel cell, once the fuel cell reaches a desired temperature. Then, after start-up and after the fuel cell has reached the desired temperature, a sufficient quantity of the

WO 01/97310

PCT/CA01/00854

- 7 -

oxidant and the fuel are supplied to the reactor, to maintain the oxidant supplied by the catalytic reactor to the fuel cell system at a desired humidity level.

Yet another aspect of the present invention provides a method of operating a fuel cell system comprising a plurality of fuel cells, each fuel cell comprising an inlet for fuel, an anode having a catalyst associated therewith for producing cations from fuel, a fuel manifold connected between the inlet and the anode for distributing fuel to the anode, an oxidant inlet means for supplying oxidant, a cathode having a catalyst associated therewith and connected to the oxidant inlet means, for producing anions from the oxidant, said anions reacting with said cations to form water on said cathode and an ion exchange membrane disposed between the anode and the cathode, for facilitating migration of cations from the anode to the cathode while isolating the fuel and the oxidant from one another, the method comprising:

(a) supplying oxidant and fuel to the fuel cells for reaction to generate electrical power and heat;

(b) supplying fuel to the catalytic reactor and oxidant to the catalytic reactor, in an amount less than the stoichiometric amount required for combustion of fuel, to ensure complete consumption of the oxidant, thereby generating a flow of heated and humidified fuel;

(c) supplying the heated and humidified fuel to the fuel cell, for reaction with oxidant known to generate electricity and heat.

This aspect of the method can include:

(a) providing a second catalytic reactor;

(b) supplying the second reactor with fuel and oxidant in an amount greater than the stoichiometric amount required for combustion of fuel, thereby generating a flow of heated and humidified oxidants; supplying the heated and humidified oxidant to the oxidant inlet means of the fuel cell, for reaction with a heated and humidified fuel to generate electricity and heat.

BRIEF DESCRIPTION OF THE DRAWING FIGURES

For a better understanding of the present invention and to show more clearly how it may be carried into effect, reference will now be made, by way of

WO 01/97310

PCT/CA01/00854

- 8 -

example, to the accompanying drawings which show a preferred embodiment of the present invention and in which:

Figure 1 is a schematic view of the first embodiment of a fuel cell system in accordance with the present invention;

5 Figure 2 is a schematic view of a second embodiment of a fuel cell system in accordance with the present invention;

Figure 3 is a schematic view of a third embodiment of a fuel cell system in accordance with the present invention;

10 Figures 4a, 4b and 4c are, respectively, perspective and side views of a tubular reactor in accordance with the present invention;

Figure 5 is a plan view of part of the fuel cell stack of Figures 1, 2, and 3;

15 Figures 6a, 6b and 6c are, respectively, planned, side and end views of a manifold for a catalytic hydrogen burner in accordance with the present invention; and

Figure 7, 8 and 9 are more detailed views of the embodiments of the fuel cell systems shown in Figures 1, 2 and 3 respectively.

DESCRIPTION OF THE PREFERRED EMBODIMENT

20 Referring first to Figures 1 and 7, the first embodiment of the apparatus is indicated generally by the reference 10 and includes an enclosure 12, in the apparatus. In the drawings, this is identified as a HyTef-FC15 enclosure.

Within the enclosure 12, there is a fuel stack 14 comprising, in known manner, a plurality of PEM fuel cells, and described in greater detail in relation to 25 Figure 5. For the stack 14, a main fuel supply line 16 is provided for hydrogen. The fuel line 16 extends into the enclosure 12 and continues as a main supply line 18 including a solenoid-operated valve 20 and a secondary fuel line 22 including a respective flow control valve 24 and a solenoid-operated valve 25. As shown, a stack purge outlet at 26 enables excess hydrogen to be purged from the fuel cell 30 stack 14. A respective solenoid controlled valve 27 controls purging of the hydrogen gas. Again, as is known, this prevents accumulation of contaminants and

WO 01/97310

PCT/CA01/00854

- 9 -

impurities in the hydrogen fuel, within the fuel cell stack 14. The purged hydrogen through the purge outlet 26 can be recycled for consumption.

The fuel cell stack 14 in Figure 1 is an air-breathing stack. Hydrogen fuel flows through the anode side of each individual fuel cell in known manner. Correspondingly, arrows 29 indicate the flow of air as an oxidant through the cathode side of each fuel cell and venting of this air flow from the top of the stack as indicated at 43 in Figures 1 and 2. The stack 14 is open at the top and bottom and provided with suitable vents, to enable free flow of air through the cathode sides of the fuel cells, as indicated by arrows 29.

In accordance with the present invention, the secondary hydrogen supply line 22 is connected to a catalytic reactor 30, which includes a catalytic reactor bed 32, comprising, for example reticulated aluminum; this material is chosen for its thermal conductivity, low cost and ease of use. A separate air inlet 34 is provided, connected via pump 36 and an air supply line 38 to the catalytic burner 30.

Excess air is supplied by the air pump 36 to the catalytic reactor 30. Hydrogen supplied to the catalytic reactor 30 reacts with the air, to generate heat. As a consequence, as indicated at 29, there is discharge from the catalytic reactor 30 of air, water and heat. In other words, the air supply from inlet 34 has, effectively, been heated and humidified. This heated humidified air then flows through the stack 14.

The catalytic reactor or burner 30 of Figure 1 is based, to a certain extent, on conventional configuration. As such, the actual catalytic reactor bed 32, of known manner, is relatively broad and has a large surface area, but at the same time it is relatively shallow, in terms of the flow direction of the gases. The intention is to relate a large area for gas flow, which in turn reduces gas velocity. This should ensure sufficient residence time for substantially complete combustion, as effected by the catalytic reactor bed 32.

In practice, it is often difficult to achieve complete combustion, and this is important in this application. Moreover, while the large surface area of the reactor bed 32 is suitable for an open configuration, it is unsuited for any closed system. Instead, the inventors have developed an elongated, tubular reactor, which

WO 01/97310

PCT/CA01/00854

- 10 -

is indicated at 50 in Figure 2. This tubular reactor 50 is described in greater detail below in relation to Figure 4. The other components in Figure 2 correspond to those in Figure 1. For simplicity and brevity, like components in Figure 2 are given the same reference numeral and the description of these components is not repeated.

5 Thus, the embodiment of Figure 2, also shown in Figure 8, functions in much the same way as the embodiment of Figure 1. However, instead of having the catalytic reactor 30 with an open surface reactor bed 32 with a large surface area, there is instead provided the enclosed tubular reactor 50. The reactor 50 has respective inlets 52 and 54 for fuel and air, and a tubular outlet 56. A flow of
10 heated, humidified air 40 exits from the tubular outlet 56, and will then flow through the open fuel cell stack 14 as indicated, again, by arrows 29. An air inlet 41 is connected to an air line 42, including air blower or pump 40.

 A non-return valve 58 and a flash arrester 59 are provided, as for the next embodiment. Reference will now be made to Figures 3 and 7, which show a
15 third embodiment of the present invention. This embodiment of the invention again can have an enclosure as indicated generally by the reference 60, and again includes a fuel cell stack 62. The stack 62 here is a closed stack, and is provided with an air pump or blower 64 connected by a main supply line 66 to an inlet of the fuel cell stack 62, and excess air exhausts from the fuel cell stack 62 as indicated at 68.

20 On the hydrogen side, a hydrogen supply line 70 can include a pressure gauge and a flow meter (not shown), and comprises a main hydrogen supply line 72 to the fuel cell stack 62 and a secondary supply line 74 to the catalytic burner or reactor 50. A solenoid valve 73 is provided in the main supply line 72, and a solenoid valve 75, a flash arrester 76 and a non-return valve 77 are provided in the
25 secondary line 74. A fuel purge valve 78 with a controlling solenoid valve 79 are provided as for the first embodiment.

 The tubular reactor 50 is again provided and the hydrogen inlet 52 is again provided at the side of the reactor.

30 An air supply line for the reactor 50 is indicated at 80 and includes a pump or meter 82, and a respective non-return valve 84. The air supply line 80 is connected to a respective inlet 54 on the catalytic reactor 50. Optionally, a pressure gauge and a flow meter can be provided (not shown).

WO 01/97310

PCT/CA01/00854

- 11 -

The outlet 56 of the tubular reactor 50 is connected by a line 85, to two branch lines 86 and 87, which are connected by respective solenoid valves 88 and 89 to the fuel supply line 72 and to the air supply line 66. Although not shown, the stack 62 can optionally include a recirculation pump. Excess hydrogen can, in a known manner, be purged through the outlet or purge line 78, to prevent build-up of contaminants.

The tubular reactor 50 can be run to provide either a humidified and heated flow of air or a humidified and heated flow of hydrogen. These two modes of operation are detailed below.

To generate a flow of heated and humidified air, excess air is delivered by the pump 82, relative to the hydrogen flow through the line 74. In the tubular reactor 50, the oxygen reacts with the hydrogen to generate heat and moisture. This results in a heated and moistened air flow exiting through the outlet 56. Then, the valve 88 is maintained closed and the valve 89 is opened, so that the heated and moistened air flow passes through to the main air supply line 66, to be entrained into the air flow passing to the fuel cell stack 62.

Correspondingly, to generate a heated hydrogen flow, the valve 88 is opened and the valve 89 closed. Then, excess hydrogen is supplied through the line 74, as compared to air supplied through the main fuel line 72. The flow is dead ended and is only exhausted during purging when the exhaust solenoid 79 is open. However, the flow can be controlled using control valves when not operated in dead-ended mode. In the tubular reactor 50, the oxygen in the air reacts with some of the hydrogen to generate heat and moisture. This leaves the flow of hydrogen, with residual nitrogen, together with heat and moisture, to then exit from the outlet 56. This flow of heated and humidified nitrogen and hydrogen gas passes through valve 88 into the main fuel line 72.

It will be appreciated that where heated and humidified hydrogen is supplied to the fuel line 72, and as air is used as the oxidant, this does result in nitrogen being injected into the fuel gas supply. For this reason, the purge line 78 will need to be used, to prevent the build-up of nitrogen within the fuel cell stack 62. Alternatively a flowing system can be used at all times.

WO 01/97310

PCT/CA01/00854

- 12 -

It is important that, in the reactor 50, complete reaction takes place. In other words, it is essential that, in the two modes of operation, residual hydrogen is not delivered to the main air line 66, nor residual oxygen delivered to the hydrogen supply line 72. This could result in potentially flammable gas mixtures of hydrogen and oxygen being delivered to the fuel cell stack 60, which is dangerous. To ensure complete reaction, proper topology and morphology of the reactor must be designed, essentially to ensure adequate residency time over the full range of flow rates.

It will also be understood that it is possible to heat and humidify both of the fuel and air supply lines. Because of the different requirements of the two supply lines, this would require the provision of two separate tubular reactors, each of which would be configured to operate in one of the two modes outlined above.

Turning to Figure 4, this shows, in detail, the tubular reactor 50. It is to be appreciated that this is an early version of the tubular reactor 50, and in particular, the housing of the reactor 50 is made from conventional, off-the-shelf components. It is anticipated that the overall configuration of the tubular reactor 50 can be enhanced to give a design which both has better performance characteristics, and is more economical to manufacture.

Referring to Figure 4, the tubular reactor 50 comprises a tubular reactor housing 51. At the lower end thereof, a T-connector 100 is provided. The T-connector 100 has three coupling flanges 102, one of which is connected to the tubular housing 51, and the two others of which provide connections for the hydrogen and air supply lines. At the top end, the tubular reactor 50 includes a connector 104, again provided with connection flanges 106, one of which is connected to the tubular body 51 and the other of which provides connection to a supply line. While a housing 51 of circular cross-section is shown, it will be understood that any suitable cross-section, for example a square cross-section, could be used.

Reference will now be made to Figure 5. This shows a plan view of five pairs of flow field plates making up five individual fuel cell elements in the fuel cell stack 62. Thus, there are oxidant flow field plates indicated at 110. Fuel flow field plates are indicated at 112. Between each pair of oxidant and fuel flow field

WO 01/97310

PCT/CA01/00854

- 13 -

plates 110,112, there is located a respective membrane electrode assembly (MEA) and gas diffusion media 114. Between the oxidant flow field plates 110 and the MEA 114, there are defined oxidant channels 116, and fuel flow hydrogen channels 118 are defined between the fuel flow field plates 112 and the MEA 114. Cooling channels 120 are provided in the back of the oxidant flow field plates 110, against the fuel flow field plates 112. These cooling channels 120 are, like the oxidant channels 116, simply channels extending vertically (not necessarily vertical) through the stack 62, to provide free flow of ambient air through the channels. In known manner, other constructional details of the stack, e.g. elements holding the various flow field plates together, are not shown, but these can be conventional.

WO 01/97310

PCT/CA01/00854

- 14 -

CLAIMS:

1. A tubular reactor, for catalyzing the reaction of hydrogen and a gaseous oxidant, the tubular reactor comprising:
 - 5 an elongated housing,
a catalyst formed from a material adapted to promote catalytic combustion of the fuel and the oxidant, being formed into an elongated body substantially filling the elongated housing and being porous, a first inlet for a gaseous fuel and a second inlet for a gaseous oxidant, both first and second inlets
10 being provided at one end of the elongated housing; and
an outlet at the other end of the housing, whereby, in use, the catalyst promotes combustion between the fuel and the oxidant to generate heat and moisture, whereby a heated and humidified gas flow exits through the outlet.
- 15 2. A tubular reactor as claimed in claim 1, wherein the housing and the body of the catalyst are both generally cylindrical and have a length substantially longer than the diameter thereof.
3. A tubular reactor as claimed in claim 1 or 2, which includes, for the first
20 and second inlets, fittings for connection to supply lines for fuel and the oxidant, and for the outlet, a fitting for connection to a conduit for receiving the heated, humidified gas flow.
4. A fuel cell system comprising:
 - 25 at least one fuel cell, each fuel cell comprising:
an inlet for a fuel;
an anode having a catalyst associated therewith for producing cations from the fuel;
a fuel manifold, connected between the inlet and the anode, for
30 distributing fuel to the anode;
an oxidant inlet means for supplying oxidant;

WO 01/97310

PCT/CA01/00854

- 15 -

a cathode having a catalyst associated therewith and connected to the oxidant inlet means, for producing anions from the oxidant, said anions reacting with said cations to form water on said cathode;

an ion exchange membrane deposited between said anode and said cathode, said membrane facilitating migration of cations from said anode to said cathode, while isolating the fuel and the oxidant from one another; and

a catalytic reactor having a first inlet for fuel and a second inlet for an oxidant, and an outlet for heated and humidified oxidant, the catalytic reactor being mounted to supply the heated and humidified oxidant to the fuel cell.

10

5. A fuel cell system as claimed in claim 4, which includes a plurality of fuel cells forming a fuel cell stack, which includes a main fuel inlet connected to all of the inlets of the fuel cells.

15

6. A fuel cell system as claimed in claim 5, wherein the fuel cell stack is an air-breathing stack, including a plurality of channels extending upwardly through the fuel cell stack for permitting free flow of ambient air as the oxidant through the fuel cell stack, there being at least one channel for each fuel cell and the oxidant inlet means being provided by the lower ends of the channels, wherein the catalytic reactor is mounted below the fuel cell stack and is configured to receive air as an oxidant through the second inlet thereof in excess of the stoichiometric quantity of air required for combustion of fuel within the catalytic reactor, whereby heated and humidified air is discharged from the outlet of the catalytic reactor, and wherein the outlet of the catalytic reactor is mounted below the channels of the fuel cell stack, whereby, heated and moistened air flows upwardly through the channels of the fuel cell stack from the catalytic reactor.

20

25

7. A fuel cell system as claimed in claim 6 which includes a supply line for fuel connected to both the main fuel inlet of the fuel cell stack and the first inlet of the catalytic reactor, and which includes an air supply line including an air delivery device connected to the second inlet of the catalytic reactor.

30

WO 01/97310

PCT/CA01/00854

- 16 -

8. A fuel cell system as claimed in claim 6 or 7 wherein the catalytic reactor is generally tubular.

9. A fuel cell system as claimed in claim 6 or 7, wherein the catalytic reactor includes a generally disc shaped reactor element, configured for flow of fuel and oxidant, generally along a central axis thereof.

10. A fuel cell system as claimed in claim 5 wherein the outlet of the catalytic reactor is connected by a first control valve to the main fuel inlet of the fuel cell stack and by a second control valve to the oxidant inlet means whereby, in use, the outlet of the catalytic reactor can be selectively connected to one of the main fuel inlet and the oxidant inlet means, with supply of the oxidant as the fuel to the catalytic reactor adjusted so that the heated and humidified gas at the outlet of the catalytic reactor includes an excess of gas corresponding to said one of the main fuel inlet and the oxidant inlet means.

11. A fuel cell system as claimed in claim 10, wherein each of the fuel supply line and the air supply line include at least one of a pressure gauge, a flow meter and a non-return valve.

12. A fuel cell system as claimed in claim 5, wherein the oxidant inlet means comprises an air distribution manifold within the fuel cell stack for distributing air, as the oxidant, to individual fuel cells, wherein a main air supply line is provided connected to the air distribution manifold, and a main fuel line is connected to the fuel inlet, and wherein a secondary fuel line branches off from the main fuel supply line and is connected to the catalytic reactor for supplying fuel.

13. A fuel cell system as claimed in claim 12, wherein the fuel cell stack includes a fuel outlet and means for recirculating fuel from the fuel outlet to the fuel inlet.

WO 01/97310

PCT/CA01/00854

- 17 -

14. A fuel cell system as claimed in claim 12, wherein the catalytic reactor is provided in the main air supply line, and wherein a second catalytic reactor is provided in the fuel cell line and a secondary air supply line connects the main air supply line to the secondary catalytic reactor, for a supply of air in an amount less than the stoichiometric amount required for combustion of fuel, whereby, the secondary catalytic reactor generates heated and humidified fuel.

15. A fuel cell system as claimed in claim 14, where each of the first and second catalytic reactors is generally tubular.

10

16. A method of operating a fuel cell system comprising a plurality of fuel cells, each fuel cell comprising an inlet for fuel, an anode having a catalyst associated therewith for producing cations from fuel, a fuel manifold connected between the inlet and the anode for distributing fuel to the anode, an oxidant inlet means for supplying oxidant, a cathode having a catalyst associated therewith and connected to the oxidant inlet means for producing anions from the oxidant, said anions reacting with said cations to form water on said cathode and an ion exchange membrane disposed between the anode and the cathode, for facilitating migration of cations from the anode to the cathode while isolating the fuel and oxidant from one another, the method comprising

20

(a) supplying fuel to the fuel cell for reaction to generate electrical power and heat;

(b) providing a catalytic reactor, supplying fuel to the catalytic reactor and supplying oxidant to the catalytic reactor, in an amount greater than the stoichiometric amount required for the combustion of the fuel, to ensure complete combustion of the fuel, thereby generating a flow of heated and humidified oxidant;

25

(c) supplying the heated and humidified oxidant to the fuel cell, for reaction with the fuel to generate electricity and heat.

17. A method as claimed in claim 16, which comprises, for initial start-up below a preset temperature, initially supplying fuel and oxidant only to the catalytic reactor to generate a flow of heated and humidified oxidant, and passing the heated

30

WO 01/97310

PCT/CA01/00854

- 18 -

and humidified oxidant through the fuel cell to preheat the fuel cell, and commencing supply of fuel to the fuel cell, once the fuel cell reaches a desired temperature.

5 18. A method as claimed in claim 16, which includes providing the catalytic reactor in a main oxidant supply line for supplying oxidant to the fuel cell stack.

10 19. A method as claimed in claim 17, which includes, after start-up and after the cell has reached the desired temperature, supplying a sufficient quantity of the oxidant and the fuel to the catalytic reactor, to maintain the oxidant supplied to the fuel cell system at a desired humidity level.

15 20. A method as claimed in claim 19, which includes supplying air as the oxidant; where the fuel cell system is an air-breathing system including vertical channels for flow of air as the oxidant; and providing only a portion of air required as the oxidant through the catalytic reactor, with additional air flowing directly through the channels of the fuel cell system.

20 21. A method as claimed in claim 16, which includes:
(a) providing a second catalytic reactor;
(b) supplying the second reactor with fuel and oxidant in an amount less than the stoichiometric amount required for combustion of fuel, thereby generating a flow of heated and humidified fuel;
(c) supplying the heated and humidified fuel to the inlet for fuel
25 of the fuel cell.

22. A method as claimed in any one of claims 16 to 21, which includes providing the fuel cell system with proton exchange membranes.

WO 01/97310

PCT/CA01/00854

1/9

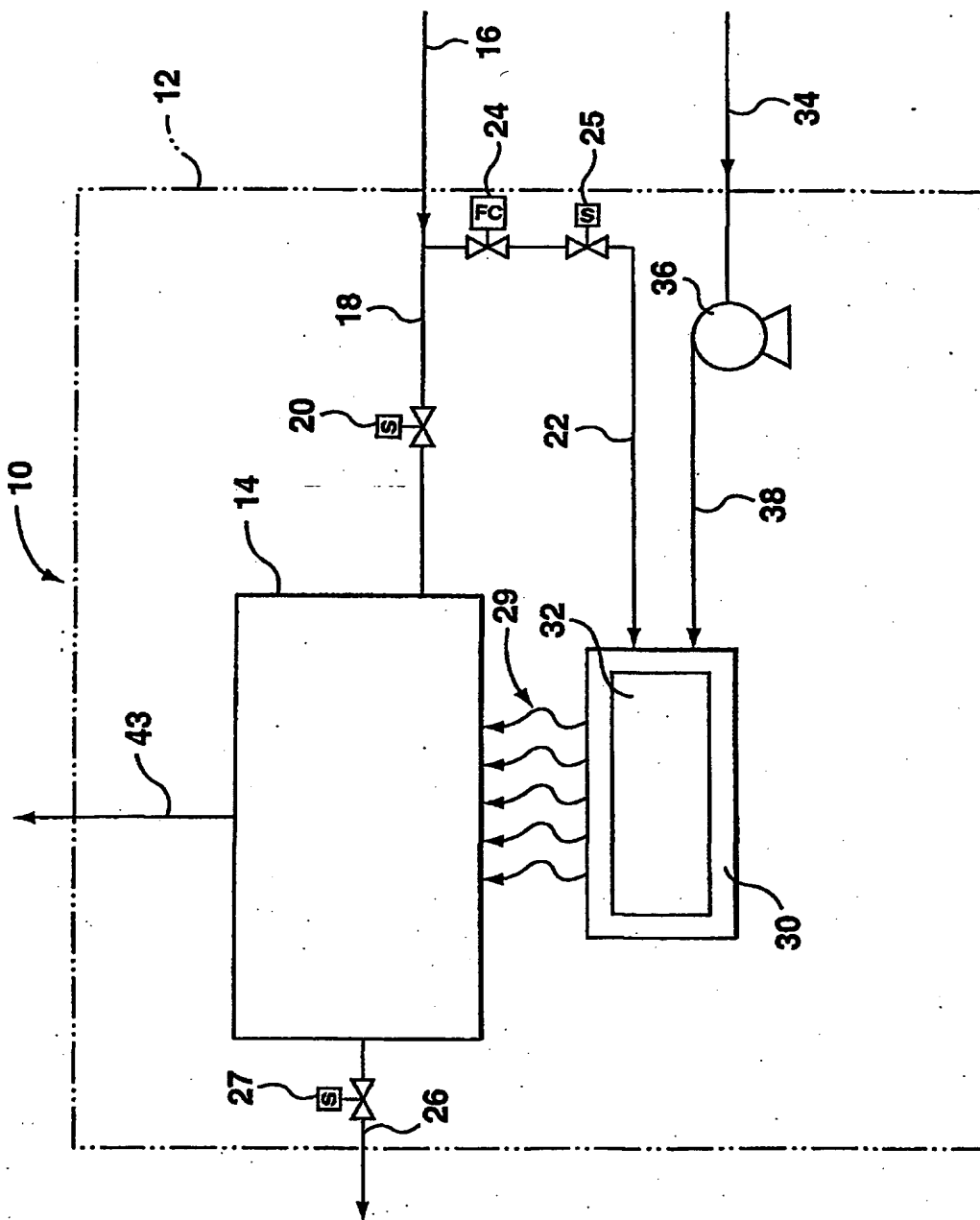


FIG. 1

SUBSTITUTE SHEET (RULE 26)

WO 01/97310

PCT/CA01/00854

2/9

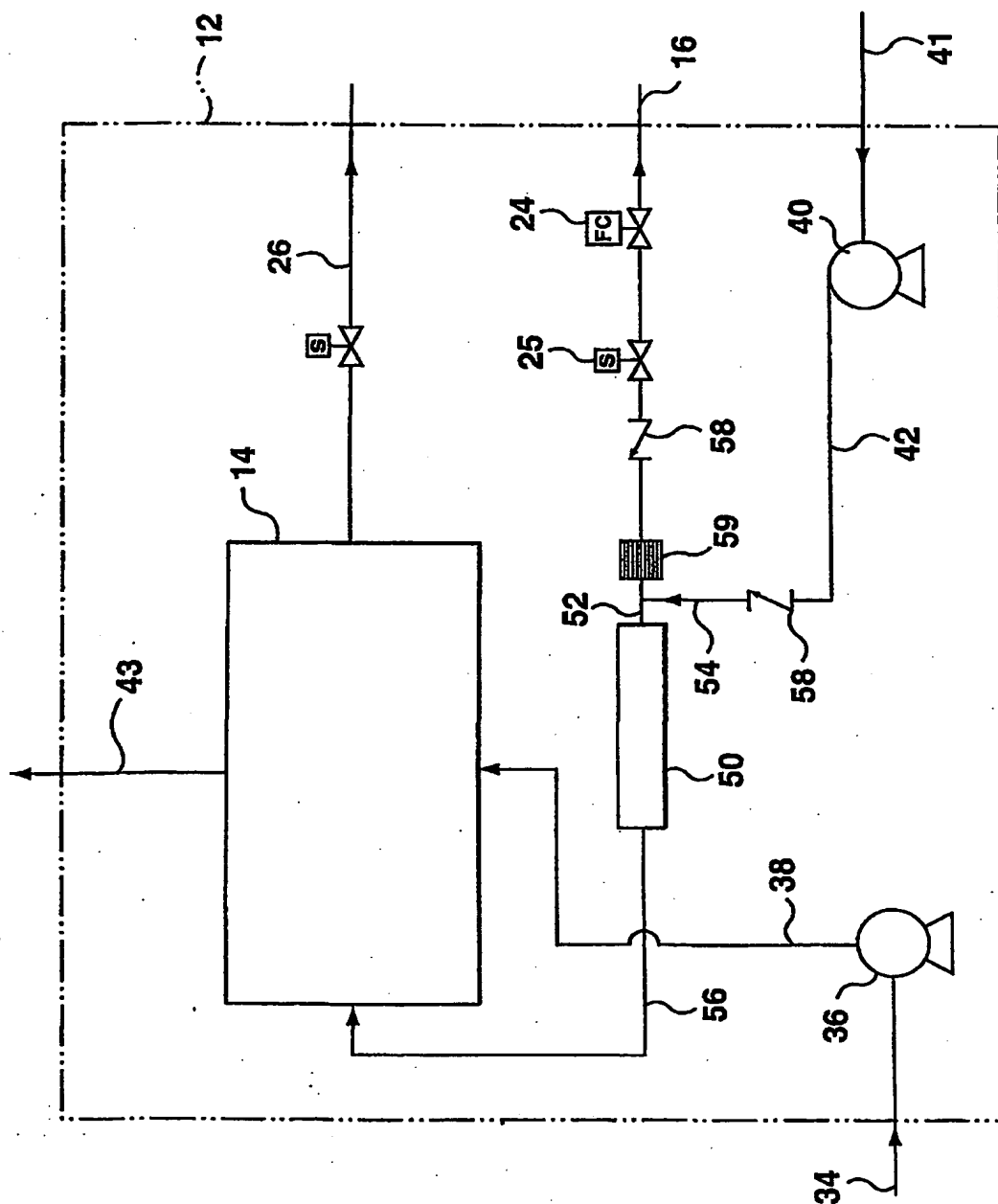


FIG. 2

SUBSTITUTE SHEET (RULE 26)

WO 01/97310

PCT/CA01/00854

3/9

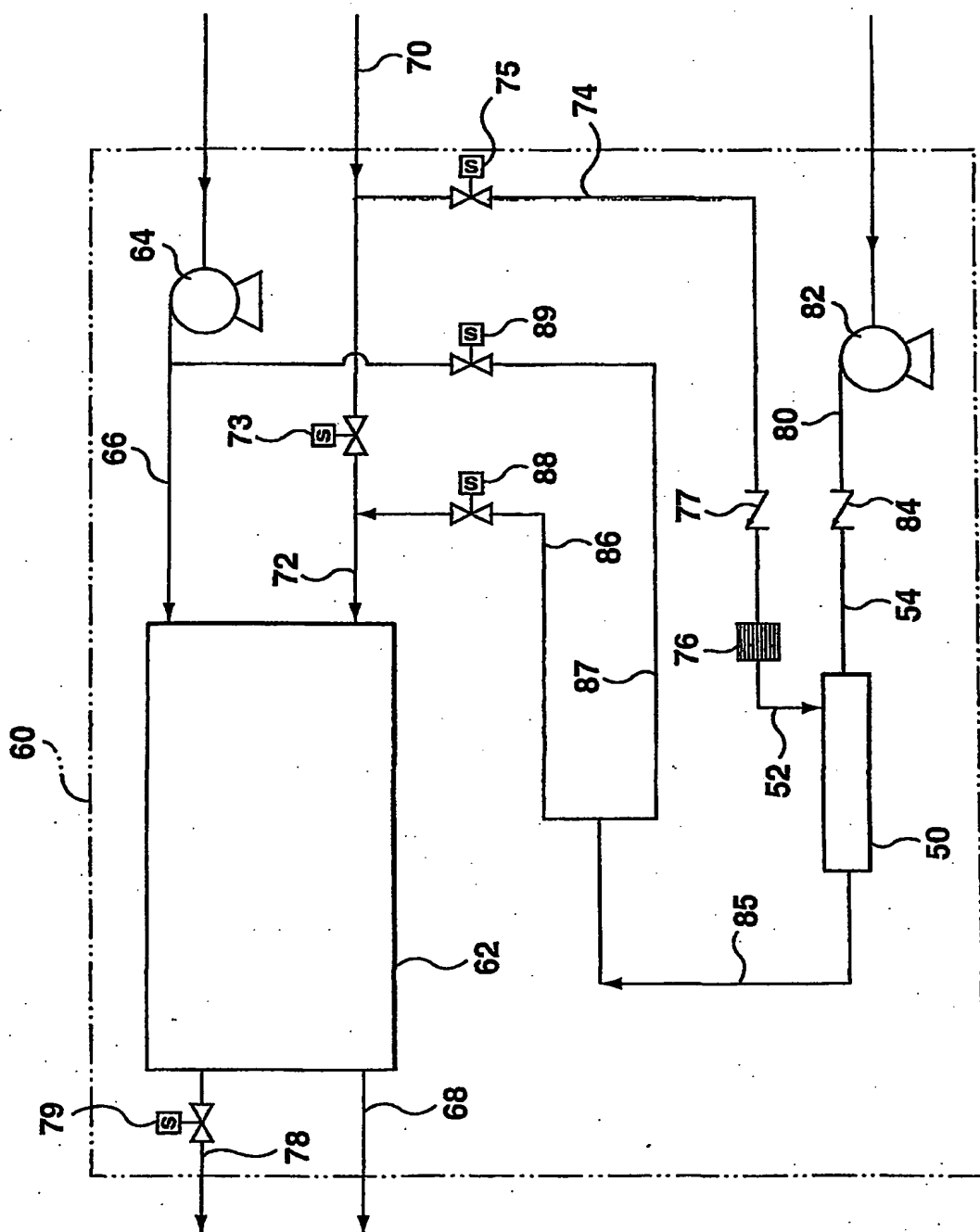


FIG. 3

SUBSTITUTE SHEET (RULE 26)

WO 01/97310

PCT/CA01/00854

4/9

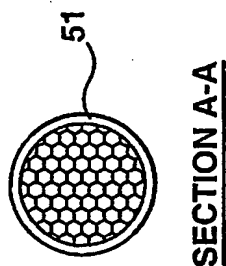


FIG. 4c

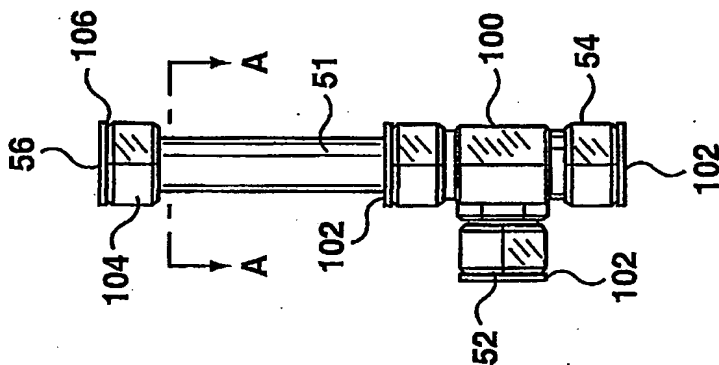


FIG. 4b

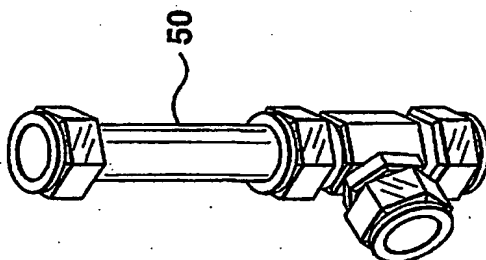


FIG. 4a

SUBSTITUTE SHEET (RULE 26)

WO 01/97310

PCT/CA01/00854

5/9

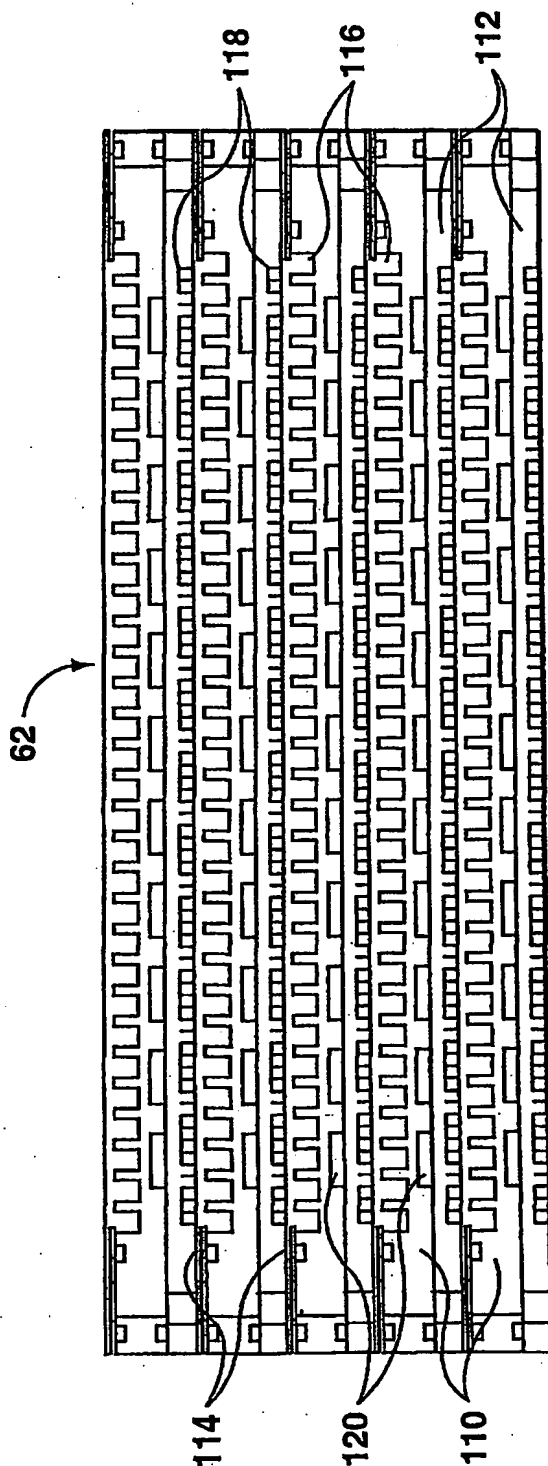


FIG. 5

SUBSTITUTE SHEET (RULE 26)

WO 01/97310

PCT/CA01/00854

6/9

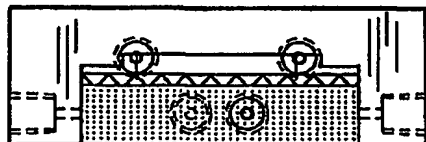


FIG. 6c

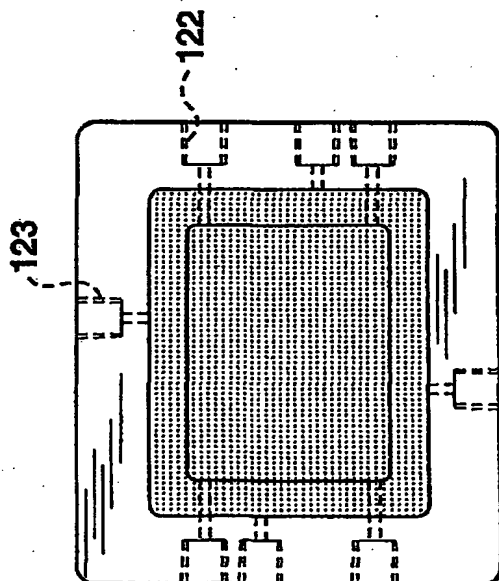


FIG. 6a

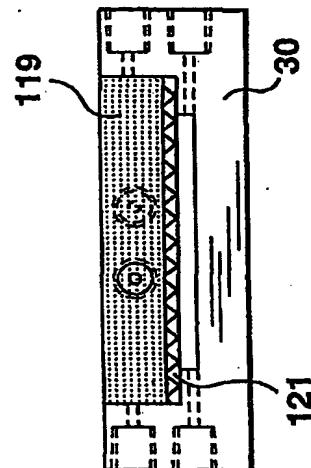


FIG. 6b

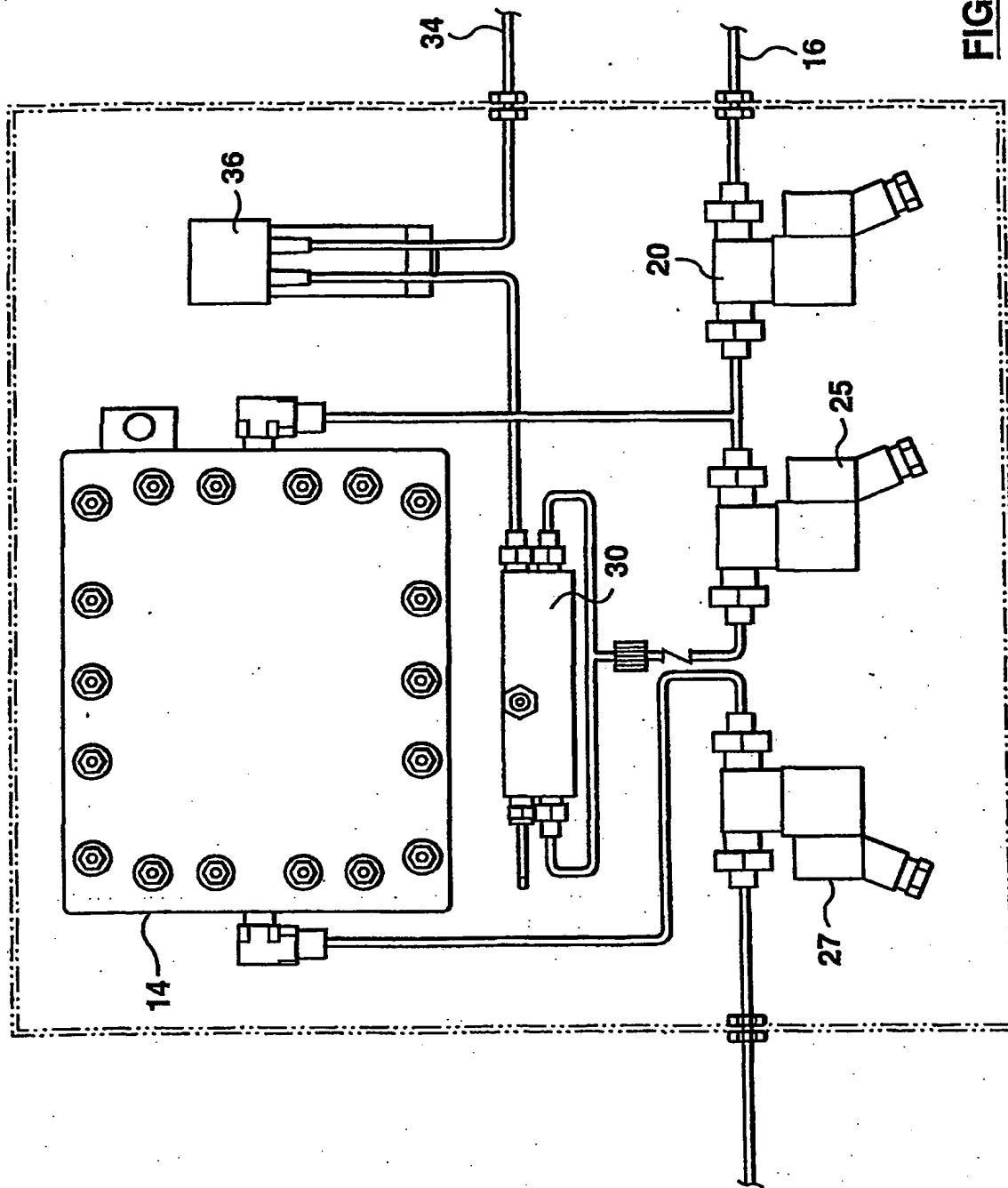
SUBSTITUTE SHEET (RULE 26)

WO 01/97310

PCT/CA01/00854

7/9

FIG. 7



SUBSTITUTE SHEET (RULE 26)

WO 01/97310

PCT/CA01/00854

8/9

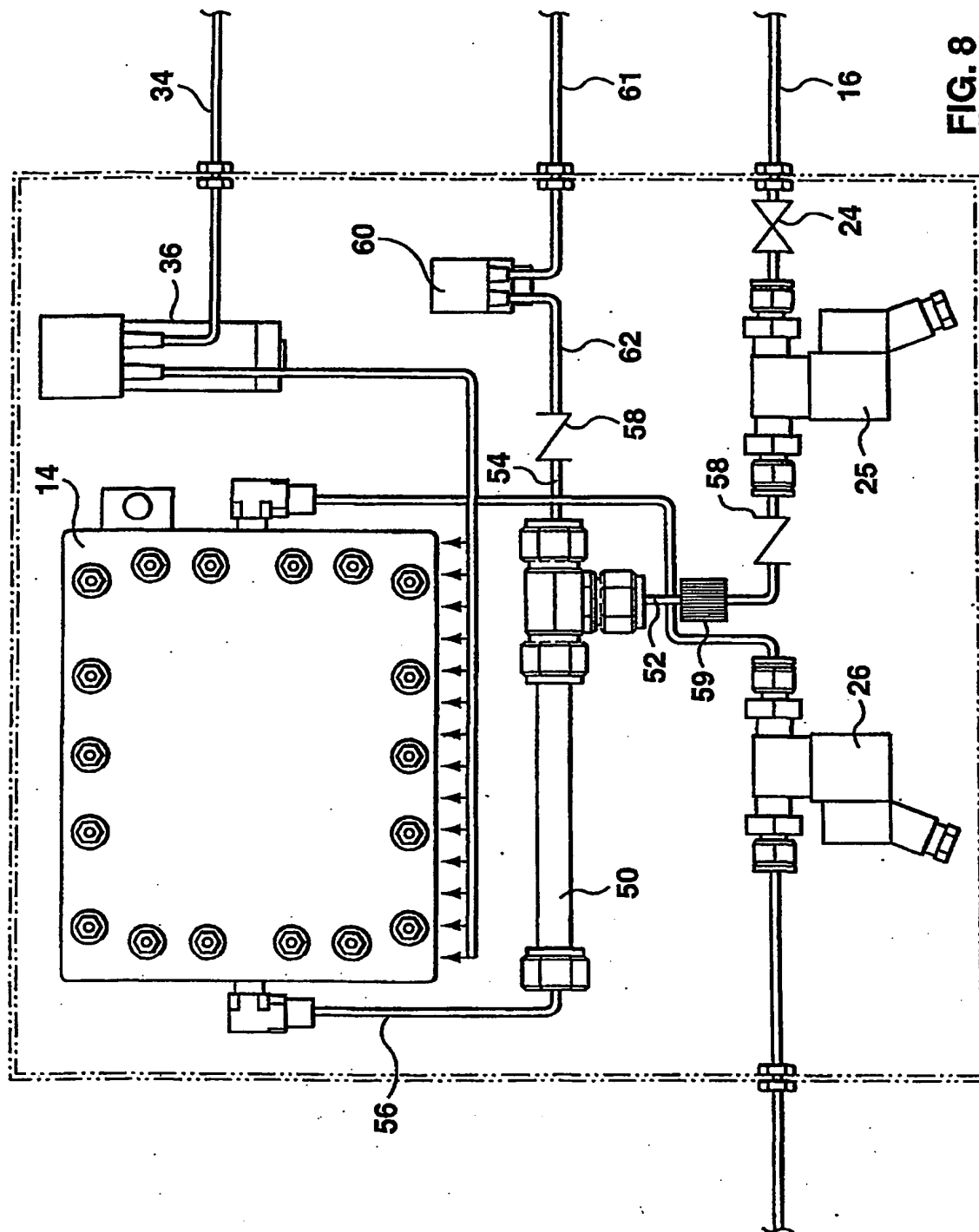


FIG. 8

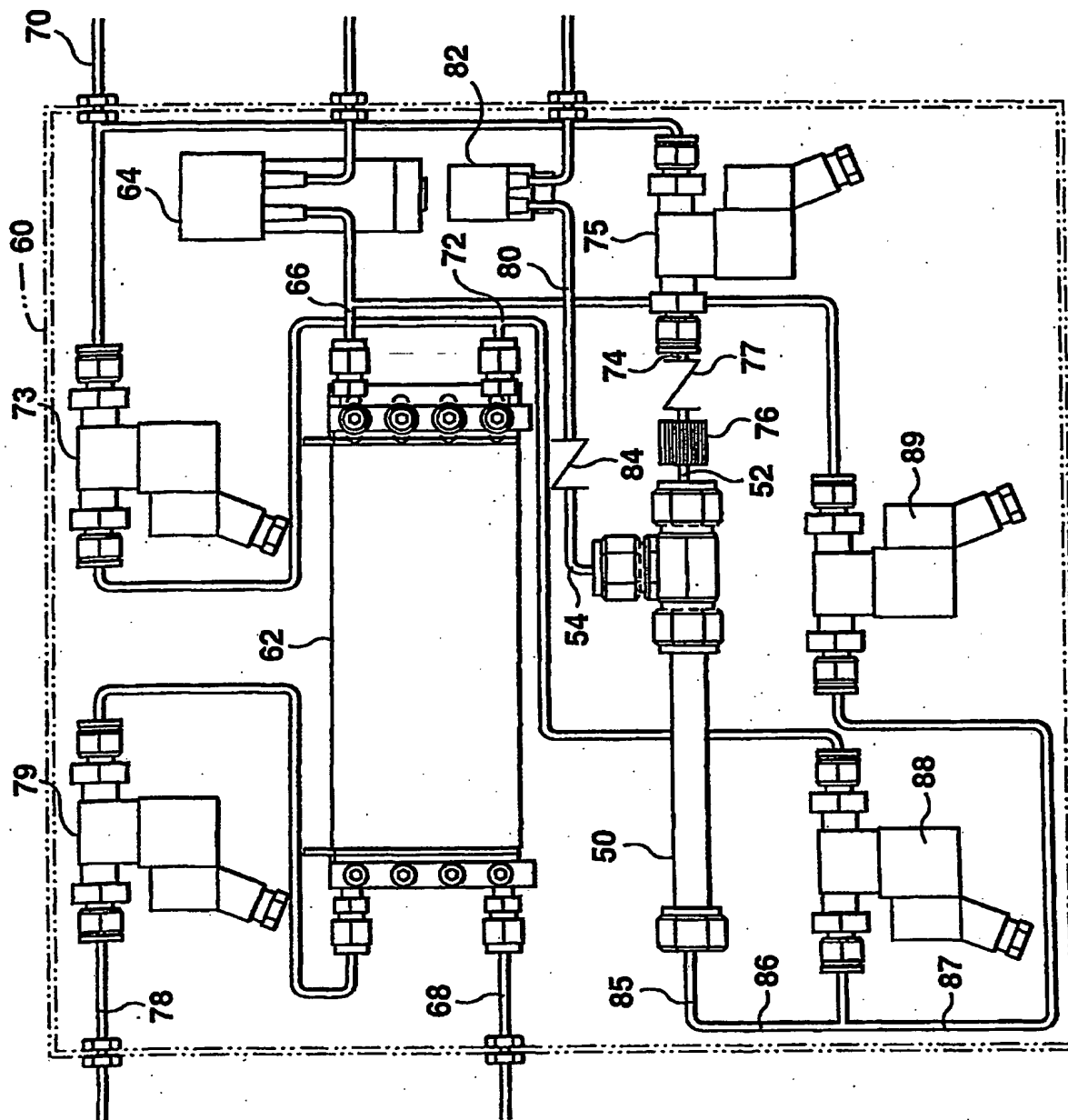
SUBSTITUTE SHEET (RULE 26)

WO 01/97310

PCT/CA01/00854

9/9

FIG. 9



SUBSTITUTE SHEET (RULE 26)

(12) INTERNATIONAL APPLICATION PUBLISHED UNDER THE PATENT COOPERATION TREATY (PCT)

(19) World Intellectual Property Organization
International Bureau(43) International Publication Date
20 December 2001 (20.12.2001)

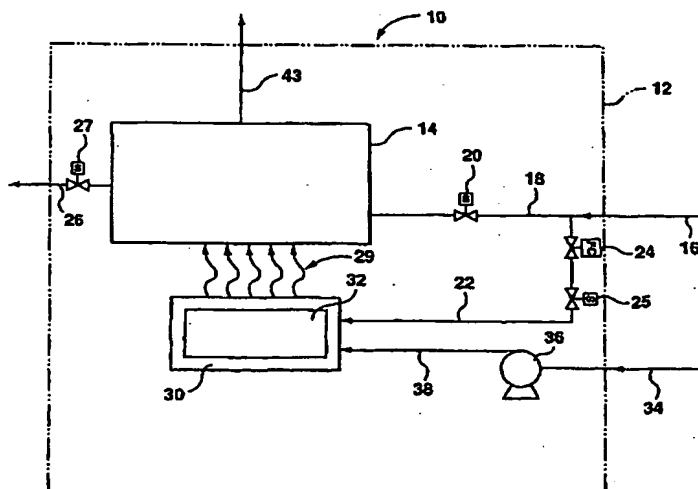
PCT

(10) International Publication Number
WO 01/097310 A3

- (51) International Patent Classification⁷: H01M 8/04, B01J 8/06, 19/24
- (21) International Application Number: PCT/CA01/00854
- (22) International Filing Date: 13 June 2001 (13.06.2001)
- (25) Filing Language: English
- (26) Publication Language: English
- (30) Priority Data:
09/592,347 13 June 2000 (13.06.2000) US
- (63) Related by continuation (CON) or continuation-in-part (CIP) to earlier application:
US 09/592,347 (CON)
Filed on 13 June 2000 (13.06.2000)
- (71) Applicant (for all designated States except US): HYDROGENICS CORPORATION [CA/CA]; 5985 McLaughlin Road, Mississauga, Ontario L5R 1B8 (CA).
- (72) Inventors; and
(73) Inventors/Applicants (for US only): FRANK, David [CA/CA]; 25 Cleethorpes Blvd., Scarborough, Ontario M1S 2S7 (CA). CHEN, Xuesong [CN/CA]; #1817 - 2 Hanover Road, Brampton, Ontario L6S 4H9 (CA). RIVARD, Pierre [CA/CA]; 113 Hove Street, Toronto, Ontario M3H 4Z5 (CA). CARGNELLI, Joseph [CA/CA]; 59 Lapp Street, Toronto, Ontario M6N 3W3 (CA).
- (74) Agent: BERESKIN & PARR; 40 King Street West, 40th Floor, Toronto, Ontario M5H 3Y2 (CA).
- (81) Designated States (national): AE, AG, AL, AM, AT, AU, AZ, BA, BB, BG, BR, BY, BZ, CA, CH, CN, CO, CR, CU, CZ, DE, DK, DM, DZ, EE, ES, FI, GB, GD, GE, GH, GM, HR, HU, ID, IL, IN, IS, JP, KI, KG, KP, KR, KZ, LC, LK, LR, LS, LT, LU, LV, MA, MD, MG, MK, MN, MW, MX, MZ, NO, NZ, PL, PT, RO, RU, SD, SE, SG, SI, SK, SL, TJ, TM, TR, TT, TZ, UA, UG, US, UZ, VN, YU, ZA, ZW.
- (84) Designated States (regional): ARIPO patent (GH, GM, KE, LS, MW, MZ, SD, SL, SZ, TZ, UG, ZW), Eurasian patent (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM), European

[Continued on next page]

(54) Title: CATALYTIC HUMIDIFIER AND HEATER, PRIMARILY FOR HUMIDIFICATION OF THE OXIDANT STREAM FOR A FUEL CELL



(57) Abstract: A method and apparatus are provided for humidifying oxidant supplied to a fuel cell system (14), which can be a single fuel cell or a multiplicity of fuel cells. A catalytic reactor (30) is provided, which is supplied with a portion of the fuel (22) and the oxidant (38). The oxidant is supplied in excess of the fuel to the reactor, so as to generate a stream of oxidant which is both heated and humidified. For an air breathing stack, this heated oxidant can simply be mixed with air flowing through the fuel cell stack. For a closed system, a heated and humidified oxidant flow, and optionally a fuel flow are mixed with additional flows of these gases supplied to the fuel cell.

WO 01/097310 A3

WO 01/097310 A3



patent (AT, BE, CH, CY, DE, DK, ES, FI, FR, GB, GR, IE, IT, LU, MC, NL, PT, SE, TR), OAPI patent (BF, BJ, CI, CG, CI, CM, GA, GN, GW, ML, MR, NE, SN, TD, TG).

(88) Date of publication of the international search report:
9 January 2003

Published:

— with international search report

For two-letter codes and other abbreviations, refer to the "Guidance Notes on Codes and Abbreviations" appearing at the beginning of each regular issue of the PCT Gazette.

INTERNATIONAL SEARCH REPORT

International Application No

PCT/CA 01/00854

A. CLASSIFICATION OF SUBJECT MATTER

IPC 7 HO1M8/04 B01J8/06 B01J19/24

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

IPC 7 HO1M B01J F23C

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the International search (name of data base and, where practical, search terms used)

EPO-Internal, WPI Data, PAJ

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	PATENT ABSTRACTS OF JAPAN vol. 007, no. 135 (C-170), 11 June 1983 (1983-06-11) -& JP 58 049431 A (DENKI KAGAKU KEIKI KK), 23 March 1983 (1983-03-23) abstract	1-3
X	EP 0 878 443 A (HITACHI LTD ;OHMI TADAHIRO (JP); FUJIKIN KK (JP)) 18 November 1998 (1998-11-18) page 5, line 4 - line 15 page 17, line 58 -page 18, line 2 page 19, line 22 - line 38 claims 1-33; figure 42	1-3
X	EP 0 666 237 A (OHMI TADAHIRO) 9 August 1995 (1995-08-09) the whole document	1-3
-/-		

☒ Further documents are listed in the continuation of box C.☒ Patent family members are listed in annex.

* Special categories of cited documents:

- *A* document defining the general state of the art which is not considered to be of particular relevance
- *E* earlier document but published on or after the international filing date
- *L* document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)
- *O* document referring to an oral disclosure, use, exhibition or other means
- *P* document published prior to the international filing date but later than the priority date claimed

T later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention

X document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone

Y document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art

G document member of the same patent family

Date of the actual completion of the international search

7 October 2002

Date of mailing of the international search report

14/10/2002

Name and mailing address of the ISA

European Patent Office, P.B. 5818 Patentlaan 2
NL - 2280 HV Rijswijk
Tel (+31-70) 340-2040, Tx. 31 651 epo nl,
Fax (+31-70) 340-3016

Authorized officer

Gamez, A

INTERNATIONAL SEARCH REPORT

II International Application No

PCT/CA 01/00854

C.(Continuation) DOCUMENTS CONSIDERED TO BE RELEVANT

Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
A	PATENT ABSTRACTS OF JAPAN vol. 015, no. 329 (M-1149), 21 August 1991 (1991-08-21) -& JP 03 125807 A (BABCOCK HITACHI KK), 29 May 1991 (1991-05-29) abstract	1-3
A	PATENT ABSTRACTS OF JAPAN vol. 013, no. 018 (E-704), 17 January 1989 (1989-01-17) -& JP 63 225477 A (MITSUBISHI ELECTRIC CORP), 20 September 1988 (1988-09-20) abstract	1,4,5, 11,16, 17,22
A	CA 2 242 176 A (BALLARD POWER SYSTEMS ;WELLS BRIAN W (CA); RONNE JOEL A (CA); VOSS) 30 December 1998 (1998-12-30) the whole document	4-6,11, 13,16, 17,22
P,A	WO 00 54356 A (VON HELMOLT RITTMAR ;MUND KONRAD (DE); GEBHARDT ULRICH (DE); LUFT) 14 September 2000 (2000-09-14) the whole document	1,4,5, 11,16, 17,22

Form PCT/ISA/210 (continuation of second sheet) (July 1992)

International Application No. PCT/CA 01 00854

FURTHER INFORMATION CONTINUED FROM PCT/SA/ 210

This International Searching Authority found multiple (groups of) inventions in this international application, as follows:

1. Claims: 1-3

A tubular reactor, for catalyzing the reaction of hydrogen and a gaseous oxidant, the tubular reactor comprising :
an elongated housing,
a catalyst formed from a material adapted to promote catalytic combustion of the fuel and the oxidant, being formed into an elongated body substantially filling the elongated housing and being porous, a first inlet for a gaseous fuel and a second inlet for a gaseous oxidant, both first and second inlets being provided at one end of the elongated housing; and
an outlet at the other end of the housing, whereby, in use, the catalyst promotes combustion between the fuel and the oxidant to generate heat and moisture, whereby a heated and humidified gas flow exists through the outlet.

2. Claims: 4-22

A fuel system comprising:
at least one fuel cell, each fuel cell comprising:
an inlet for a fuel;
an anode having a catalyst associated therewith for producing cations from the fuel;
a fuel manifold, connected between the inlet and the anode, for distributing fuel to the anode;
an oxidant inlet means for supplying oxidant;
a cathode having a catalyst associated therewith and connected to the oxidant inlet means, for producing anions from the oxidant, said anions reacting with said cations to form water on said cathode;
an ion exchange membrane deposited between said anode and said cathode, said membrane facilitating migration of cations from said anode to said cathode, while isolating the fuel and the oxidant from one another; and
a catalytic reactor having a first inlet for fuel and a second inlet for an oxidant, and an outlet for heated and humidified oxidant, the catalytic reactor being mounted to supply the heated and humidified oxidant to the fuel cell.
Also claimed the method of operating this fuel cell system.

INTERNATIONAL SEARCH REPORT

International application No.
PCT/CA 01/00854**Box I Observations where certain claims were found unsearchable (Continuation of item 1 of first sheet)**

This International Search Report has not been established in respect of certain claims under Article 17(2)(a) for the following reasons:

1. ☐ Claims Nos.:
because they relate to subject matter not required to be searched by this Authority, namely:
2. ☐ Claims Nos.:
because they relate to parts of the International Application that do not comply with the prescribed requirements to such an extent that no meaningful International Search can be carried out, specifically:
3. ☐ Claims Nos.:
because they are dependent claims and are not drafted in accordance with the second and third sentences of Rule 6.4(a).

Box II Observations where unity of invention is lacking (Continuation of item 2 of first sheet)

This International Searching Authority found multiple inventions in this international application, as follows:

see additional sheet

1. ☐ As all required additional search fees were timely paid by the applicant, this International Search Report covers all searchable claims.
2. ☒ As all searchable claims could be searched without effort justifying an additional fee, this Authority did not invite payment of any additional fee.
3. ☐ As only some of the required additional search fees were timely paid by the applicant, this International Search Report covers only those claims for which fees were paid, specifically claims Nos.:
4. ☐ No required additional search fees were timely paid by the applicant. Consequently, this International Search Report is restricted to the invention first mentioned in the claims; it is covered by claims Nos.:

Remark on Protest

- ☐ The additional search fees were accompanied by the applicant's protest.
- ☐ No protest accompanied the payment of additional search fees.

INTERNATIONAL SEARCH REPORT
 information on patent family members

International Application No

PCT/CA 01/00854

Patent document cited in search report		Publication date	Patent family member(s)	Publication date
JP 58049431	A	23-03-1983	NONE	
EP 0878443	A	18-11-1998	AU 1456797 A	22-08-1997
			EP 0878443 A1	18-11-1998
			JP 3110465 B2	20-11-2000
			US 2001042344 A1	22-11-2001
			CA 2244688 A1	07-08-1997
			WO 9728085 A1	07-08-1997
EP 0666237	A	09-08-1995	JP 6115903 A	26-04-1994
			EP 0666237 A1	09-08-1995
			WO 9407795 A1	14-04-1994
JP 03125807	A	29-05-1991	NONE	
JP 63225477	A	20-09-1988	NONE	
CA 2242176	A	30-12-1998	CA 2242176 A1	30-12-1998
			US 2002058168 A1	16-05-2002
			US 6106964 A	22-08-2000
WO 0054356	A	14-09-2000	CN 1343379 T	03-04-2002
			WO 0054356 A1	14-09-2000
			EP 1166381 A1	02-01-2002
			US 2002058165 A1	16-05-2002

**This Page is Inserted by IFW Indexing and Scanning
Operations and is not part of the Official Record**

BEST AVAILABLE IMAGES

Defective images within this document are accurate representations of the original documents submitted by the applicant.

Defects in the images include but are not limited to the items checked:

- ☐ BLACK BORDERS
- ☐ IMAGE CUT OFF AT TOP, BOTTOM OR SIDES
- ☒ FADED TEXT OR DRAWING
- ☒ BLURRED OR ILLEGIBLE TEXT OR DRAWING
- ☐ SKEWED/SLANTED IMAGES
- ☐ COLOR OR BLACK AND WHITE PHOTOGRAPHS
- ☐ GRAY SCALE DOCUMENTS
- ☐ LINES OR MARKS ON ORIGINAL DOCUMENT
- ☐ REFERENCE(S) OR EXHIBIT(S) SUBMITTED ARE POOR QUALITY
- ☐ OTHER: _____

IMAGES ARE BEST AVAILABLE COPY.

As rescanning these documents will not correct the image problems checked, please do not report these problems to the IFW Image Problem Mailbox.